

Insert 2-Sided Ø23 Z2

A08-200

This special insert is ground in one setup from a blank, on which the front- and backface are preground. After probing the orientation and eccentricity, the references sides are ground using a cup wheel and oscillation movements - as well for the 8 mm thickness and 10 mm reference of 20 degrees. The profile is ground with a pregrinding and finishing operation. In the same setup the oblique chipbreaker is also ground.



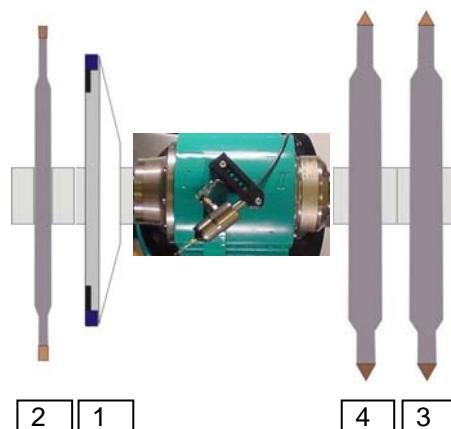
1. Cycletime for Production

Workpiece: special blank 8x8x23 Material CARBIDE						
Operations	Probe	Sides	Ref.Sides	Chipbreaker	Pregrinding	Finishing
Feed [mm/Min]	2000	5000	5000	1800	20	50
Power [kW]		1	1	1	1	1
Cutting speed [m/s]		22	22	22	20	22
Used wheels		1	1	2	3	4
Grinding time [s]	20	37	41	45	174	100
Total cycle time	6 Min 56					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12C9 Ø250 D64
2	14A1 Ø250 D64
3	14V1 Ø300 D64V40°
4	14V1 Ø300 D46V40°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories: TTC Clamping, Robot

Responsable engineer: OP. 27.12.11

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